

**What is claimed is:**

1. A machine tool adapted to fix a workpiece on a workpiece spindle by non-self-aligning clamp means, the machine tool comprising:

a centering jig to be attached to a tool spindle;  
and

a run-out measuring device for measuring a run-out of the workpiece resulting from off-center of the workpiece mounted on the workpiece spindle;

wherein, when the workpiece is to be fixed to the workpiece spindle by the clamp means, the centering jig is attached to the tool spindle, and the tool spindle is moved on the basis of the run-out of the workpiece measured by the run-out measuring device to center the workpiece by the centering jig.

2. A machine tool adapted to fix a workpiece to a workpiece spindle by non-self-aligning clamp means, the machine tool comprising:

a tool magazine which accommodates a plurality of tools;

an automatic tool changer for exchanging a tool between the tool magazine and a tool spindle; and

a run-out measuring device for measuring a run-out of the workpiece resulting from off-center of the workpiece mounted on the workpiece spindle;

wherein a centering jig to be attached to the tool spindle is accommodated in the tool magazine;

wherein, when the workpiece is to be fixed to the workpiece spindle by the clamp means, the centering jig is taken out of the tool magazine and attached to the tool spindle by the automatic tool changer, and the tool spindle is moved on the basis of the run-out of the workpiece measured by the run-out measuring device to center the workpiece by the centering jig.